

(19) World Intellectual Property Organization
International Bureau



(43) International Publication Date
10 July 2003 (10.07.2003)

PCT

(10) International Publication Number
WO 03/056509 A1

(51) International Patent Classification?: **G06K 19/077**

Samuli [FI/FI]; Leppäkatu 5 as 9, FIN-33100 TAMPERE (FI).

(21) International Application Number: **PCT/FI02/01044**

(74) Agent: **GUSTAFSSON, Helmer**; UPM-Kymmene Corporation, P.O. Box 40, FIN-37601 VALKEAKOSKI (FI).

(22) International Filing Date:
19 December 2002 (19.12.2002)

(81) Designated States (*national*): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NO, NZ, OM, PH, PL, PT, RO, RU, SC, SD, SE, SG, SK, SL, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, YU, ZA, ZM, ZW.

(25) Filing Language: English

(26) Publication Language: English

(30) Priority Data:
20012549 21 December 2001 (21.12.2001) FI

(84) Designated States (*regional*): ARIPO patent (GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE, SI, SK,

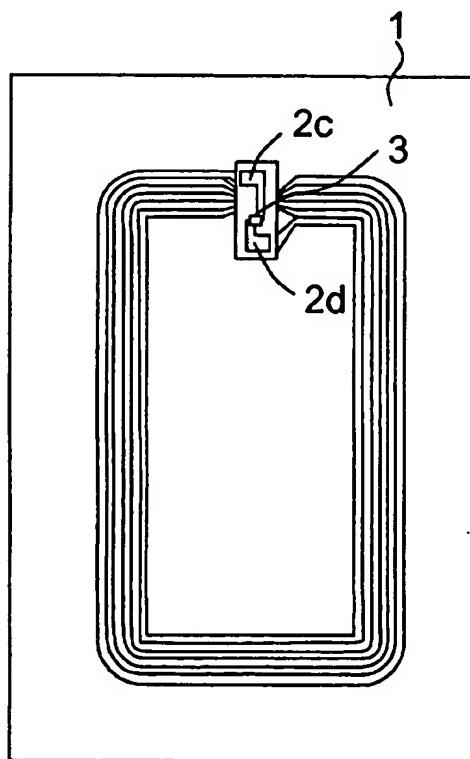
(71) Applicant (*for all designated States except US*): **RAFSEC OY** [FI/FI]; P.O. Box 53, FIN-33101 TAMPERE (FI).

(72) Inventor; and

(75) Inventor/Applicant (*for US only*): **STRÖMBERG,**

[Continued on next page]

(54) Title: **A SMART LABEL WEB AND A METHOD FOR ITS MANUFACTURE**



(57) Abstract: The present invention relates to manufacture of a smart label web, the smart label web comprising smart labels (1) one after another and/or side by side. The smart label web comprises also a circuitry pattern (2) and an integrated circuit (3) on a chip attached to it. In the method, an electric contact is formed between the integrated circuit on the chip (3) and the circuitry pattern (2) on the smart label of the smart label web in such a way that a structural part (4) separated from a separate carrier web and containing the integrated circuit on the chip (3) is electrically connected to the smart label by pressing mechanically. The structural part (4) or the smart label comprises a thermoplastic film (4a) whereby the structural part is attached to the smart label (1) substantially entirely.

WO 03/056509 A1



TR), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

Published:

— *with international search report*

A smart label web and a method for its manufacture

The present invention relates to a method for the manufacture of a smart label web, the smart label web comprising smart labels one after another and/or side by side, which comprise a circuitry pattern and an integrated circuit on a chip attached to it, and in which method, an electric contact is formed between the integrated circuit on the chip and the circuitry pattern on the smart label of the smart label web in such a way that a structural part separated from a separate carrier web and containing the integrated circuit on the chip is electrically connected to the smart label by pressing mechanically. The present invention also relates to a smart label web comprising smart labels one after another and/or side by side, which comprise a circuitry pattern and a structural part comprising an integrated circuit on a chip, which is electrically connected to the circuitry pattern by a joint made by mechanical pressing.

For attaching an integrated circuit on a chip in such a way that it is in electrical contact with a circuitry pattern, methods are known for direct attachment of the chip by flip-chip technology, or the chip can be attached in such a way that a separate structural part, onto whose surface the chip is attached, is connected to the smart label.

Methods based on flip-chip technology have for example the following disadvantages:

- the production line is complicated, expensive and inconvenient in view of further development, because all the operations are integrated on the same line, and
- the placement of the chip on the smart label requires that the tool used has a long path and also that the chip is positioned very precisely in the correct location.

The smart label can also be provided with a separate structural part comprising an integrated circuit on a chip, attached on a film material. The electrical contact between the integrated circuit on the chip and the

2

circuitry pattern of the smart label is formed so that the film material of the separate structural part comprises a conductive layer which is connected to the chip and which layer is brought into contact with the circuitry pattern in connection with the manufacture of the smart label
5 by connecting both ends of the strip-like structural part to the circuitry pattern, that is, the structural part is off the smart label in the area between its ends. The structural part is attached to that side of the smart label on whose opposite side the circuitry pattern is located so that the chip comes against the smart label.

10

The above-mentioned methods involve for example the following problems:

- 15 - In some existing smart labels, the distance between the structural part and the circuitry pattern and simultaneously the distance between the integrated circuit on the chip and the circuitry pattern are changed by bending, because the structural part is not wholly attached to the smart label, wherein the stray capacitance affecting the frequency of the electrical oscillating circuit is changed,
20 and
- the smart label has a relatively thick construction, which is disadvantageous in further processing steps.

25 By means of the method and the smart label web according to the invention, it is possible to reduce the above-mentioned problems. The method of the invention for the manufacture of a smart label web is characterized in that the structural part or the smart label comprises a thermoplastic film whereby the structural part is attached to the smart
30 label substantially entirely. The smart label web according to the invention is characterized in that the structural part or the smart label comprises a thermoplastic film whereby the structural part is attached to the smart label substantially entirely.

35 The use of thermoplastic films provides *e.g.* the following advantages:

- thermoplastic films can be repeatedly formed by applying heat,

- 5 - the distance between the structural part and the circuitry pattern as well as the distance between the integrated circuit on the chip and the circuitry pattern is fixed, because the structural part is wholly attached to the smart label by the thermoplastic film, wherein the stray capacitance affecting the frequency of the electrical oscillating circuit cannot be changed, and
- 10 - the thermoplastic film isolates the circuitry pattern from the chip, so they can contact each other only at predetermined contact points.

The use of a separate structural part provides *e.g.* the following advantages:

- 15 - the process of attachment of the chip is independent of the size and geometry of the circuitry pattern,
- 20 - the picking up of a chip from a wafer and its placement on a carrier web is a simple and fast process, because only a short path is required of the turning tool,
- 25 - as the structural part is small in size, it can contain materials which are more expensive but have better properties, such as more thermoresistant materials or materials with better dimension stability, and
- 30 - the attachment of the structural part to the smart label can be made with greater tolerances than the direct attachment of the chip to the circuitry pattern of the smart label.

The method according to the invention provides *e.g.* the following advantages:

- 35 - efficient and reliable production,
- sufficient reliability and strength of the product,

- minimum fixed and variable costs per smart label web,
- flexible production technology, and
- remaining development potential.

In the present application, smart labels refer to labels comprising an RF-ID circuit (identification) or an RF-EAS circuit (electronic article surveillance). A smart label web consists of a sequence of successive and/or adjacent smart labels. The circuitry pattern can be manufactured by pressing the circuitry pattern with an electroconductive printing ink on a film, by etching the circuitry pattern on a metal film, by punching the circuitry pattern from a metal film, or by winding the circuitry pattern of for example copper wire. Typically the circuitry pattern is formed by etching it on the metal film. The electrically operating RFID (radio frequency identification) circuit of the smart label is a simple electric oscillating circuit (RCL circuit) operating at a determined frequency. The circuit consists of a coil, a capacitor and an integrated circuit on a chip. The integrated circuit comprises an escort memory and an RF part which is arranged to communicate with a reader device. Also the capacitor of the RCL circuit can be integrated in the chip or it can be located outside the chip. When the capacitor is located outside the chip, it is formed by plates on the smart label web and the structural part. The plates are located one upon the other thereby forming the capacitor in a ready smart label.

The smart label web is of a material that is flexible but still has a suitable rigidity, such as polycarbonate, polyolefine, polyester, polyethylene terephthalate (PET), polyvinyl chloride (PVC), or acrylonitrile / butadiene / styrene copolymer (ABS).

In the method according to the invention, a carrier web comprising a base web is first manufactured. The base web can be of the same material as the smart label web but the choice of the material depends for example on the embodiment of the invention to be applied. The

surface of the base web is provided with a conductive metal coating for electrical contacts of structural parts.

5 The wafer is normally supplied for use in attaching processes so that the chips are separated from each other, on a carrying film supported by a frame. The single chips are detached in the process by pushing the chip mechanically from underneath the carrying film and by gripping the chip from the opposite side with a die bonder or die sorter utilizing an underpressure suction.

10 Integrated circuits on chips are attached one after another and/or next to each other on the surface of the base web by using flip-chip technology. The chips are picked up from the silicon wafer by means of a die sorter and placed in a continuous manner onto the surface of the
15 base web. Possible techniques to attach the chip to the base web include technologies known as such, such as placing a chip by a die sorter on a piece of a blister tape attached to the smart label. The chip can also be placed in a recess formed in the base web. Then contact pads of the chip are in the level of the upper surface of the base web or
20 they are formed at the ends of the chip. The other way to put a chip into a recess is to put it so that the active side of the chip is on the upper level of the chip. The chip is in two previous cases relatively thin, at the most 70 μm , typically 50 – 70 μm . Because the dimensions of the structural part to be formed of the carrier web are small, it is
25 possible to place chips relatively close to each other on the carrier web, and thereby long paths will not be needed for attaching the chip. With short paths, it is possible to implement sufficiently accurate positioning more easily than on attachment of the chip directly to the circuitry pattern. Furthermore, the position of the chip on the structural part may
30 vary within a larger range.

A thermoplastic film is attached to that side of the base web which has the conductive metal coatings for electrical contacts of the structural parts and the chip. The thermoplastic film is formed on the base web
35 by lamination or extrusion. The thermoplastic film may include a two layer structure in which the outer layer of the thermoplastic film melts or softens at a lower temperature than the inner layer of the thermoplastic

film. The inner layer remains unchanged and keeps its thickness while the outer layer adheres to the smart label when the thermoplastic film is heated to a suitable temperature. Thus the capacitance of the capacitor formed by plates on the smart label and the structural part remains constant. The two layer structure is achieved by co-extrusion or lamination. Films that can be heat-sealed, for example polyolefines or polyurethane, or hot melt adhesives can be laminated on the base web. Extruded films are formed on the base web in a molten state. Suitable materials to be extruded are for example polyethyleneterephthalate (PET), polyolefines (PE, PP), polyvinylchloride (PVC), polycarbonate (PC) or acrylonitrile / butadiene / styrene copolymer (ABS).

In the next step, structural parts comprising an integrated circuit on a chip are separated from a carrier web, and the structural parts are attached to the circuitry pattern of a smart label in a web containing smart labels. The structural part is preferably attached to that side of the smart label, on which the circuitry pattern is provided, although attachment to the reverse side is also possible. The attachment is made so that the structural part is attached by applying heat and pressure to each smart label on the smart label web in such a way that the thermoplastic film is in contact with the smart label and the side of the base web is left as the outer surface of the structural part. The structural part is substantially fully attached to the smart label, wherein a reliable bond is achieved. The structural part can be attached first slightly to the smart label by using heat to melt or soften the thermoplastic film. The final bond can be made in a nip, in a series of nips or in some other arrangement capable of producing pressure and/or heat.

The electrical contact between the circuitry pattern and the integrated circuit on the chip is achieved by a joint made by mechanical pressing. The term mechanical pressing means that the joint is made by applying pressure to get a physical contact between the counterparts or the counterparts are so close to each other that an electrical contact between them is possible. At least one end of the structural part is attached to the smart label by applying pressure, the other end can

make an electrical contact through a capacitor formed by plates on the smart label and the structural part which are aligned one upon the other in the ready smart label. The manufacture of the carrier web and the manufacture of the smart label web can take place in the same
5 process or in separate processes.

In the following, the invention will be described with reference to the appended drawings, in which

- 10 Fig. 1a shows a circuitry pattern of a smart label in a top view,
Fig. 1b shows a structural part in a top view,
Fig. 1c shows a ready smart label according to the invention in a
15 top view, and
Fig. 2 illustrates the structure of the structural part in a cross-section.
- 20 Figure 1a shows a circuitry pattern 2 of a smart label 1. During processing, smart labels are in a web form, the web comprising successive and/or adjacent smart labels. The ends of the circuitry pattern are indicated with reference numbers 2a and 2b.
- 25 Figure 1b shows a structural part 4. The structural part 4 comprises a base web 4b, an integrated circuit 3 on a chip and a thermoplastic film 4a, attached to the surface of the base web (shown in Fig. 2). The contact points made of conductive material are indicated with reference numbers 2c and 2d.
- 30 Figure 1c shows a smart label 1 comprising a circuitry pattern 2 and an integrated circuit 3 on a chip, attached to the surface of a separate structural part 4. An electrical contact is formed between the circuitry pattern 2 and the integrated circuit 3 on the chip by aligning points 2b and 2c in one end of the structural part and points 2a and 2d in the
35 other end of the structural part. The joint is made by mechanical pressing from at least one end of the structural part. The structural

part 4 is attached to the smart label 1 in such a way that substantially the whole area of its one side is attached to the smart label 1 by means of a thermoplastic film. The integrated circuit on the chip 3 is left between the base web 4b and the thermoplastic film 4a. The structural
5 part 4 and/or the circuitry pattern 2 of the smart label can be provided with bumps for providing an electrical contact. The bumps can be provided before the lamination or the extrusion of the thermoplastic film on the same production line on which the chip is attached to the base web in such a way that suitable bumps, whose material can be a
10 suitable metal, are formed at the ends of the structural part 4. So-called stud bumps can be formed at this process step by means of a gold wire bonder but they are not essential.

Fig. 2 shows the cross-section of the structural part 4. The structural
15 part comprises an integrated circuit on a chip 3, a thermoplastic film 4a, and a layer 4b consisting of the base web. On the surface where the thermoplastic film 4a is attached, the layer 4b is provided with the conductive metal coating of the structural part.

20 The above-described facts do not restrict the invention, but the invention may vary within the scope of the claims. The manufacture of the carrier web and the manufacture of the smart label web can take place in the same process or they can be separate processes. The process of manufacture of the smart label web can be continued so that the
25 other layers to be joined to the surface of the smart label web are attached in the same process, even so that the attachment is made simultaneously with the final bond of the structural part. The thermoplastic film can also be on the smart label and its size is at least as large as that of the structural part but the thermoplastic film can also
30 cover the whole smart label thus at the same time protecting the smart label. The main idea of the present invention is that a separate structural part comprising an integrated circuit on a chip can be attached to a smart label substantially entirely by using a thermoplastic film. Thus problems occurred due to the changing stray capacitance
35 can be avoided.

Claims:

1. A method for the manufacture of a smart label web, the smart label web comprising smart labels (1) one after another and/or side by side, which comprise a circuitry pattern (2) and an integrated circuit (3) on a chip attached to it, and in which method, an electric contact is formed between the integrated circuit on the chip (3) and the circuitry pattern (2) on the smart label of the smart label web in such a way that a structural part (4) separated from a separate carrier web and containing the integrated circuit on the chip (3) is electrically connected to the smart label by pressing mechanically, **characterized** in that the structural part (4) or the smart label comprises a thermoplastic film (4a) whereby the structural part is attached to the smart label (1) substantially entirely.
2. The method according to claim 1, **characterized** in that a dispenser is arranged to place structural parts in a focused manner onto the smart label (1).
3. The method according to claims 1 or 2, **characterized** in that the structural part (4) is attached to the smart label (1) by applying heat and pressure.
4. A smart label web (W2) comprising smart labels (1) one after another and/or side by side, which comprise a circuitry pattern (2) and a structural part (4) comprising an integrated circuit on a chip (3), which is electrically connected to the circuitry pattern by a joint made by mechanical pressing, **characterized** in that the structural part (4) or the smart label comprises a thermoplastic film (4a) whereby the structural part is attached to the smart label substantially entirely.

1/2

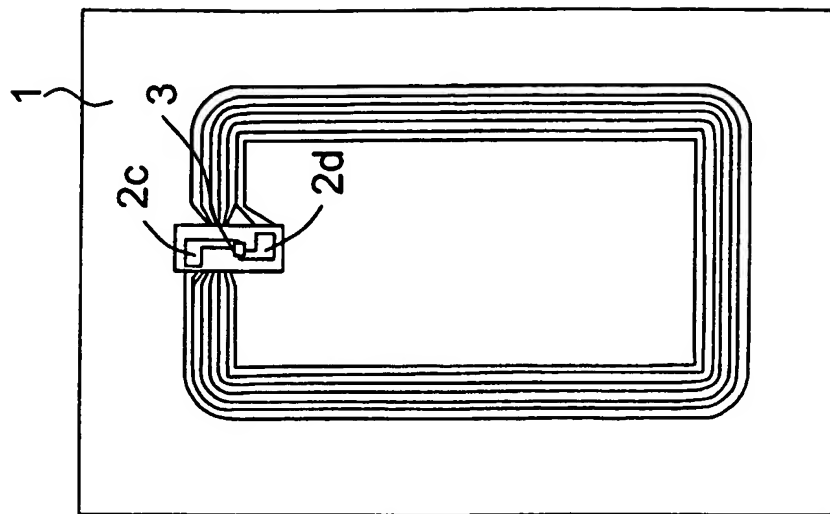


Fig. 1c

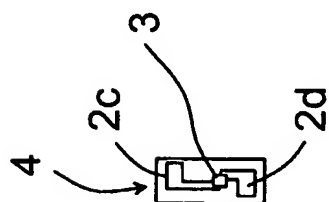


Fig. 1b

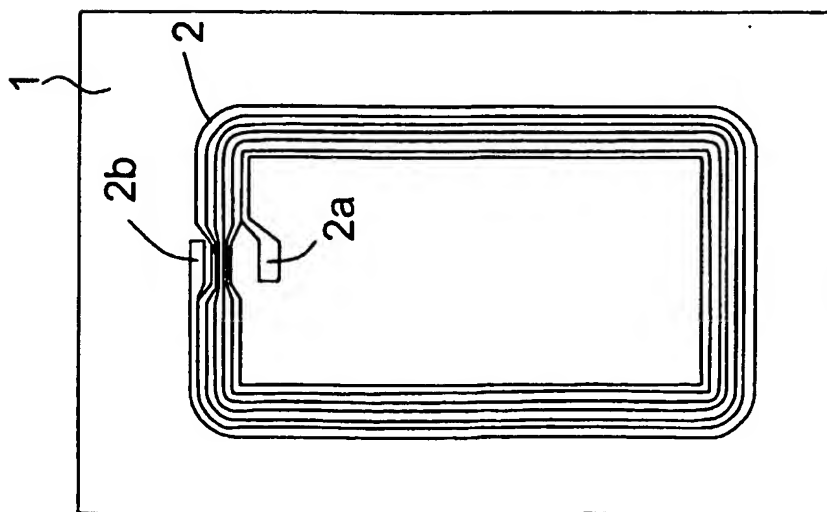


Fig. 1a

2/2

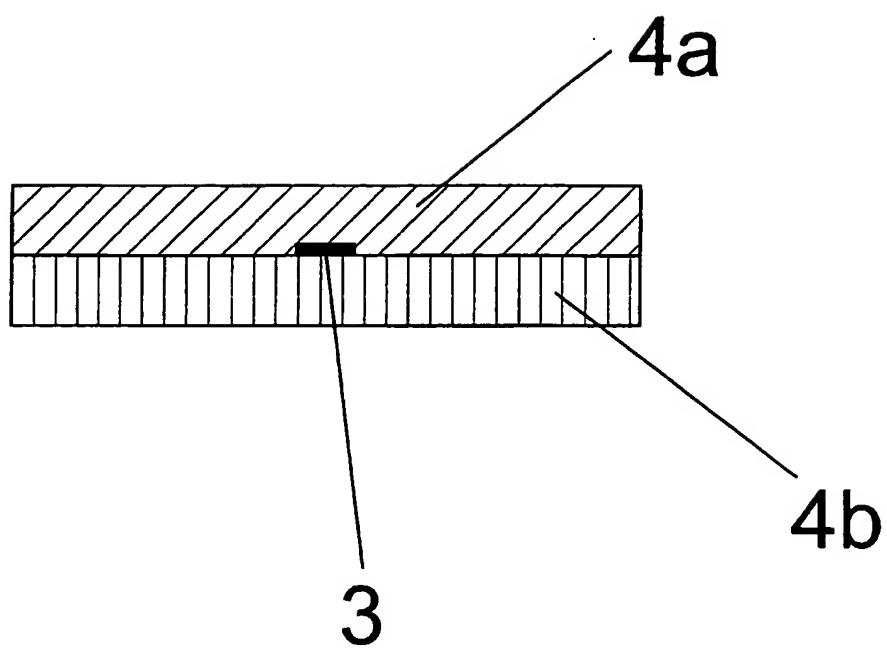


Fig. 2.

INTERNATIONAL SEARCH REPORT

PCT/FI 02/01044

A. CLASSIFICATION OF SUBJECT MATTER

IPC7: G06K 19/077

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC7: G06K

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

SE,DK,FI,NO classes as above

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

EPO-INTERNAL, WPI DATA

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 5962840 A (Y. HAGHIRI-TEHRANI ET AL), 5 October 1999 (05.10.99), column 5, line 1 - line 28, figure 7 --	1-4
X	FR 2780534 A1 (SOLAIC), 31 December 1999 (31.12.99) --	1-4
X	EP 0706152 A2 (FELA HOLDING AG), 10 April 1996 (10.04.96) --	1-4
X	US 5935497 A (R. ROSE), 10 August 1999 (10.08.99) --	1-4

☒ Further documents are listed in the continuation of Box C.☒ See patent family annex.

* Special categories of cited documents:

"A" document defining the general state of the art which is not considered to be of particular relevance

"E" earlier application or patent but published on or after the international filing date

"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)

"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance: the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance: the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art

"&" document member of the same patent family

Date of the actual completion of the international search

5 March 2003

Date of mailing of the international search report

12 -03- 2003

Name and mailing address of the ISA/
Swedish Patent Office
Box 5055, S-102 42 STOCKHOLM
Facsimile No. +46 8 666 02 86

Authorized officer

Helena Rennermalm / MRo
Telephone No. +46 8 782 25 00

INTERNATIONAL SEARCH REPORT

PCT/FI 02/01044

C (Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	DE 19915765 A1 (CUBIT ELECTRONICS GMBH), 19 October 2000 (19.10.00) --	1-4
X	US 5598032 A (J.-C. FIDALGO), 28 January 1997. (28.01.97) -- -----	1-4

INTERNATIONAL SEARCH REPORT

30/12/02

PCT/FI 02/01044

Patent document cited in search report			Publication date	Patent family member(s)		Publication date
US	5962840	A	05/10/99	DE	4446369 A	27/06/96
				EP	0723244 A	24/07/96
				EP	0723245 A	24/07/96
				JP	8230368 A	10/09/96
				JP	8340080 A	24/12/96

FR	2780534	A1	31/12/99	NONE		

EP	0706152	A2	10/04/96	AT	167319 T	15/06/98
				DE	59502482 D	00/00/00

US	5935497	A	10/08/99	DE	19623923 A	02/01/97
				FR	2735714 A,B	27/12/96
				GB	2302307 A,B	15/01/97
				GB	9612097 D	00/00/00
				JP	9020093 A	21/01/97

DE	19915765	A1	19/10/00	NONE		

US	5598032	A	28/01/97	EP	0671705 A	13/09/95
				FR	2716281 A,B	18/08/95
				JP	8052968 A	27/02/96